

What is claimed is:

1. A method of making shingles comprising:

coating a shingle mat with roofing asphalt to make an asphalt-coated sheet;

covering the asphalt-coated sheet with granules to form a granule-covered sheet

5 along a longitudinal axis, the granule-covered sheet having a shadow patch thereon,
the shadow patch having a first width along the longitudinal axis;

dividing the granule-covered sheet into an overlay sheet and an underlay sheet,
the shadow patch being on the underlay sheet;

cutting a pattern of tabs and cutouts in the overlay sheet, one of the tabs of the
10 pattern being a select tab having a second width along the longitudinal axis, the second
width of the select tab being less than the first width of the shadow patches;

synchronizing the relative longitudinal positions of the shadow patch and the
select tab;

laminating the overlay sheet and the underlay sheet, including covering a
15 portion of the synchronizing shadow patch with the select tab to leave a remainder
portion of the shadow patch uncovered by the select tab, and

creating remainder portions of different widths on different shingles by varying
the longitudinal positions of the select tab and the shadow patches with respect to each
other.

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2. The method of claim 1 wherein the synchronizing of the position of the
series of shadow patches and the select tab is done approximately randomly.

3. The method of claim 1 wherein the synchronizing of the position of the
25 series of shadow patches and the select tab is done according to a pattern.

4. The method of claim 1 wherein the first width of the shadow patches is a
constant width.

5. The method of claim 1 wherein the remainder portion of at least one of the shadow patches is synchronized with the select tab of the continuous granule-covered sheet.

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6. The method of claim 1 wherein the remainder portion includes a vertical portion positioned approximately perpendicular to the longitudinal axis.

7. The method of claim 1 wherein the remainder portion includes a
10 longitudinal portion positioned approximately parallel to the longitudinal axis.

8. A method of making shingles, wherein the shingles include an overlay portion and an underlay portion comprising:

15 establishing a continuous overlay sheet having a pattern of tabs and cutouts;

establishing a continuous underlay sheet having a series of shadow patches;

sensing the position of the pattern of tabs and cutouts on the continuous shingle overlay sheet;

20 sensing the position of the series of shadow patches on the continuous shingle underlay sheet;

synchronizing the position of the continuous overlay sheet with respect to the continuous underlay sheet in response to the sensed position of the pattern of tabs and cutouts and the sensed position of the series of shadow patches;

25 laminating the continuous overlay sheet and the continuous underlay sheet; and creating remainder portions of different widths on different shingles by varying the positions of the continuous overlay sheet and the continuous underlay sheet with respect to each other.

9. The method of claim 8 wherein the synchronizing of the position of the continuous overlay sheet with respect to the continuous underlay sheet is done approximately randomly.

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10. The method of claim 8 wherein the synchronizing of the position of the continuous overlay sheet with respect to the continuous underlay sheet is done according to a pattern.

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11. The method of claim 8 wherein the remainder portion of at least one of the shadow patches is generally aligned with the pattern of tabs of the continuous granule-covered sheet.

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12. The method of claim 8 wherein the shingles include a longitudinal axis and the remainder portion includes a vertical portion positioned approximately perpendicular to the longitudinal axis.

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13. The method of claim 8 wherein the shingles include a longitudinal axis and the remainder portion includes a longitudinal portion positioned approximately parallel to the longitudinal axis.

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14. A set of shingles having an appearance that varies from shingle to shingle, each of the shingles having an overlay sheet and an underlay sheet:
each overlay sheet having a plurality of tabs, at least one of the tabs being a select tab; and
each underlay sheet having one or more shadow patches, at least one of the shadow patches of each shingle defining a remainder portion when the select tab covers a portion of the at least one shadow patches,

wherein the positions of the select tab and the shadow patches vary with respect to each other from shingle to shingle, thereby causing the appearance of the remainder portion to vary from shingle to shingle.

5 15. The set of shingles of claim 14 wherein the select tab includes a bottom edge and the some of the remainder portion is visible along the bottom edge of the select tab.

10 16. The method of claim 14 wherein the shingles include a longitudinal axis and the remainder portion includes a vertical portion positioned approximately perpendicular to the longitudinal axis.

15 17. The method of claim 14 wherein the shingles include a longitudinal axis and the remainder portion includes a longitudinal portion positioned approximately parallel to the longitudinal axis.

18. A set of shingles having an appearance that varies from shingle to shingle:

20 each shingle having a plurality of tabs, at least one of the tabs being a select tab; and

 each shingle having one or more shadow patches, at least one of the shadow patches of each shingle defining a remainder portion when the select tab covers a portion of the at least one shadow patches,

25 wherein the relative longitudinal positions of the select tab and at least one shadow patch vary with respect to each other from shingle to shingle, thereby causing the appearance of the remainder portion to vary from shingle to shingle.